

Work Order ID 76995

76995

Page 1

November-24-11 2:45:12 PM

Item ID: D3407-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ring
 Start Date: 24/11/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3407
 17.4 256 X 4" Dwg Rev: EE
 Prog Rev: EE
 2-Break edges on grinder as per Dwg D3407

B12-1-3
12/01/12 (32)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B12-1-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 76995

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November-24-11 2:45:12 PM

Item ID: D3407-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ring

Start Date: 24/11/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 08/12/2011 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: *W/A*

0.00

130

Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

W/A
X32

EL 12-1-16 *X32*

12/1/16 *JD*

CMF
12-01-16

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NOTE: Date & initial all entries

Picklist Print

November-24-11 2:45:16 PM

Page 1

Work Order ID: 76995

76995

Parent Item: D3407-5

D3407-5

Parent Item Name: Ring

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 05-11-22 JLM
IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000		Purchased			No	100	f	7.6700	0.2666	11.22526			

M174B0 250X4 000

17-4 SS Bar .250 X 4.00

**

B 12-1-3

Location

Loc Qty

Loc Code

MAT050

7.67

119101

7.67

119101

(32)
out of MAT

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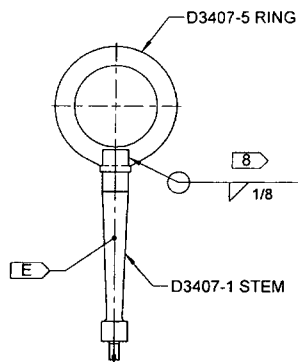
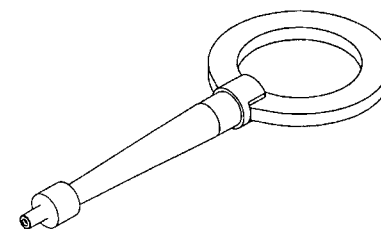
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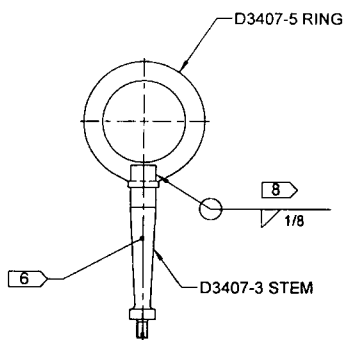
NOTE: Date & initial all entries

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

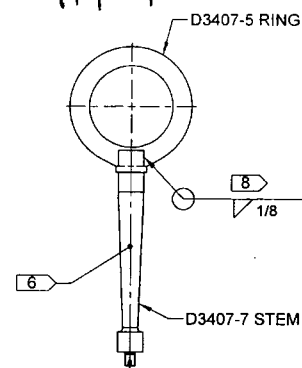
UNCONTROLLED COPY
 RETURN TO
 DART AEROSPACE
 SUBJECT TO RECALL
 W/ NO NOTICE
 W/ NO ORDER
 NO. 76995-4.2.5
 11/11/24



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT WWASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.23		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO.		REV.	
D3407		SHEET 1 OF 5	
TOW RING		SCALE	
		NTS	
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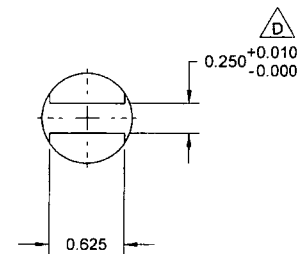
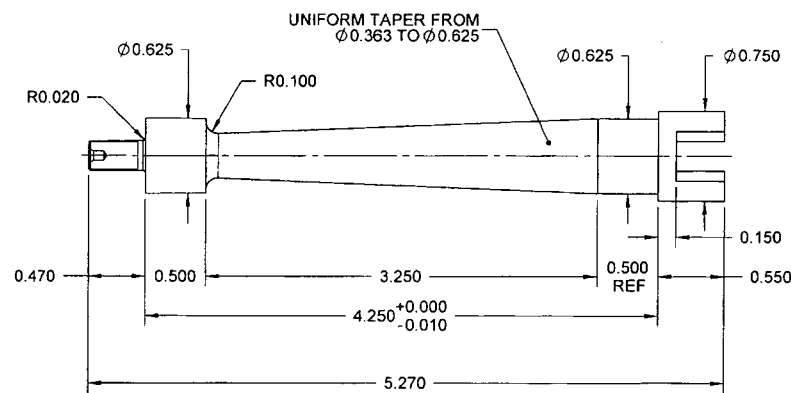
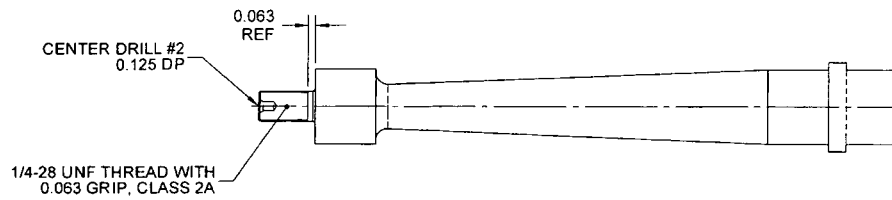
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76995



D3407-1 STEM

RELEASED

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

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MFG. APPR.		D3407	SHEET 2 OF 5
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DE APPR.		TOW RING	NTS
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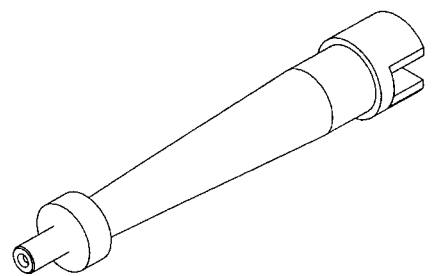
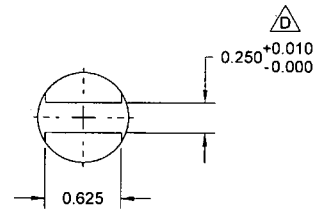
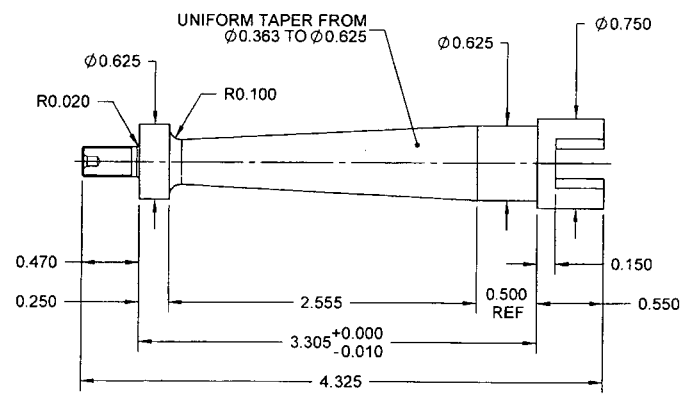
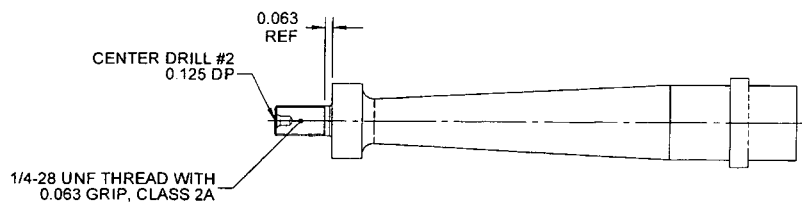
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76995



D3407-3 STEM

RELEASED

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

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MFG. APPR.		D3407	SHEET 3 OF 5
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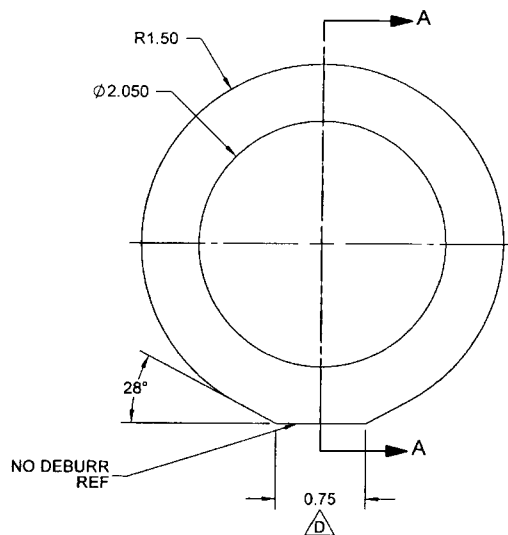
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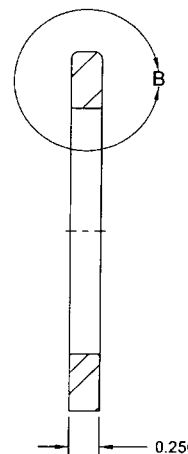
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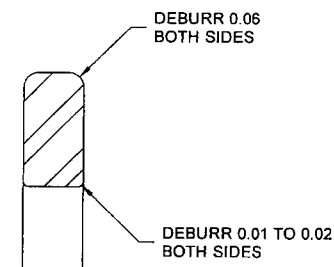
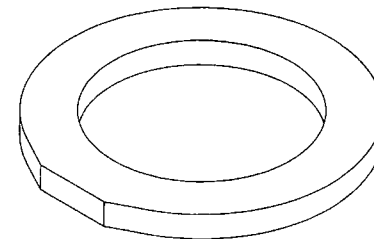
76995



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED
08-06-01-11-11

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	90	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
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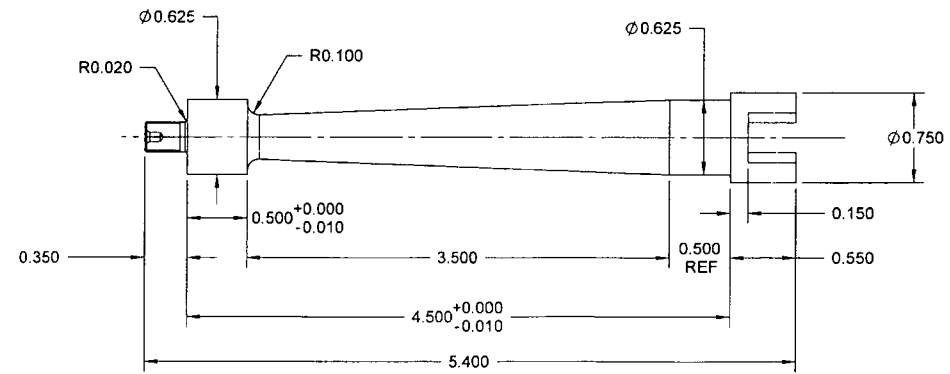
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76995

0.063
REF
CENTER DRILL #2
0.125 DP

1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
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